

Del 1.25

## Work Order ID 68972



Page 1

Tuesday, April 26, 2011 2:28:48 PM

Item ID: D3417-5

Accept



Setup Start



Revision ID:

Item Name: Washer

Stop



Start Date: 4/26/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan:



Date: 11/04/24 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D3417	Rev E	

100



Hardinge CNC LATHE SMALL

0.00

70 0

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA761  
 Rev: NF &  
 Dwg D3417 Rev: E  
 2-Deburr

SK 11/16/17

110



QC2- Inspect parts off machine FAI/FAIB

0.00

40 0

QC

Memo

0.00

SK 11/15/17

120



QC8- Inspect parts - second check

0.00

SK 11/05/09

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 68972**

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Page 2

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Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

130



Packaging

Packaging

140



QC

Quality Control

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInspec.  
StampIdentify as per dwg & Stock Location: 053

0.00

Memo

0.00

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Key of S (40)11/05/09MF  
11-05-09

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Page 1

Tuesday, April 26, 2011 2:28:53 PM

Work Order ID: 68972



Parent Item: D3417-5



Parent Item Name: Washer

Start Date: 4/26/2011

Required Date: 4/29/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A  New issue  08-07-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.2500 		Purchased		No		110	f	20.0840	0.0296	1.246316 		SA 105/8	

DELRIN ROUND BAR 1.25"

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT055	20.084	
114586	20.084	1.5 ft

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	68972
Description: Washer	Part Number:	D3417-5
Inspection Dwg: D3417	Rev: E	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

Measured by:		Audited by:		Preliminary Approval:	
Date:	1/15/07	Date:	11/09/05	Date:	

Rev	Date	Change	Revised by	Approved
A	09.05.04	New Issue	KJ/DD	
B	10.11.12	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

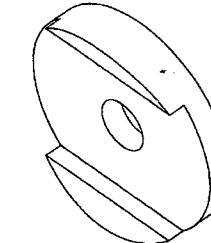
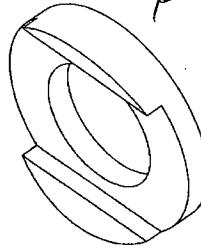
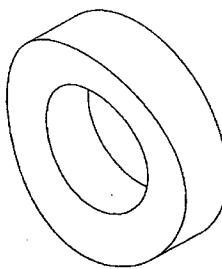
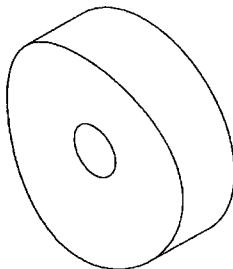
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SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 68972

PL1104-24

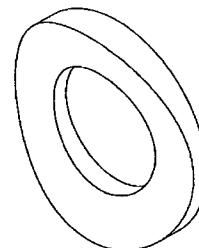


D3417-1 WASHER

D3417-3 WASHER

D3417-5 WASHER

D3417-7 WASHER



D3417-9 WASHER

△

NOTES:

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD  
REF DART SPEC M-DELRIN-R  
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR  
REF DART SPEC M-DELRIN-B  
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET  
REF DART SPEC M-DELRIN-S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3417-1, 0.020 lbs  
D3417-3, 0.010 lbs  
D3417-5, 0.010 lbs  
D3417-7, 0.010 lbs  
D3417-9, 0.004 lbs

RELEASED  
2010-09-15  
W.W.

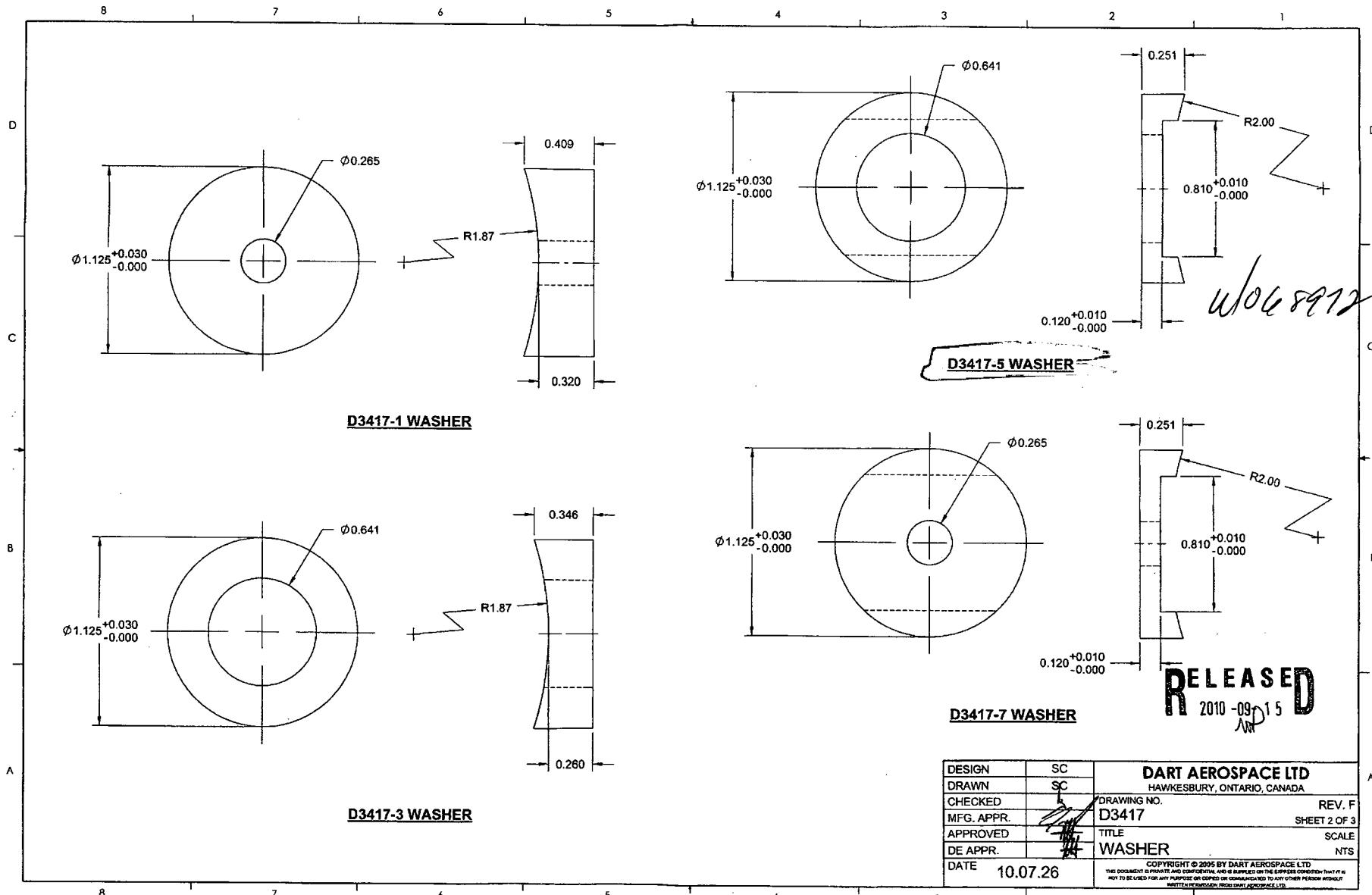
F	ADD D3417-8 (ZN B5-3)	SC	10.07.26
E	ADD D3417-7 (ZN A2-2)	RF	09.06.30
D	ADD-5 WASHER (ZN B2-1, B2-2); REFORMAT TO "B" SIZE & UPDATE TO CURRENT STANDARDS; REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE CBORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1	DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
DATE	10.07.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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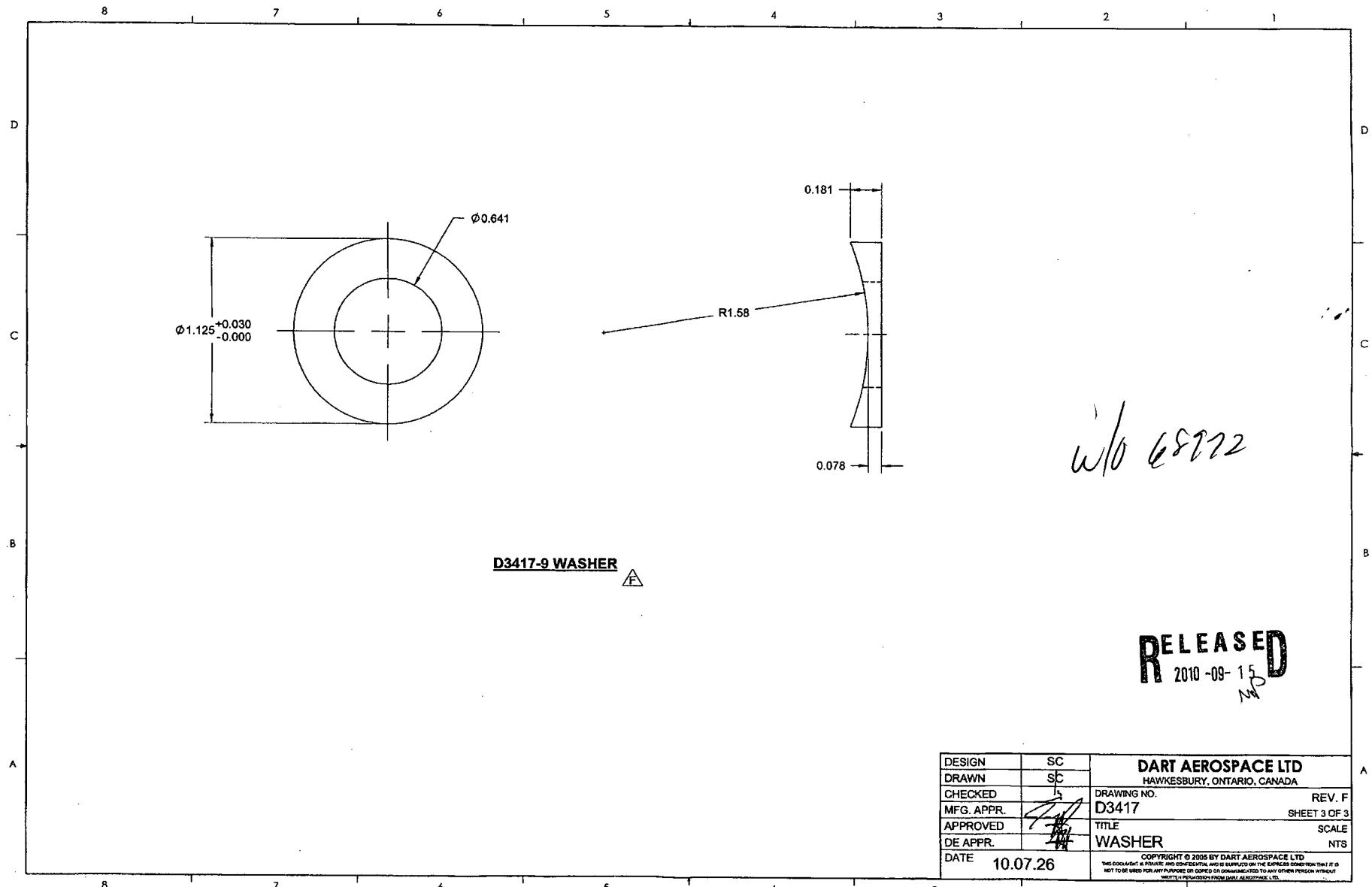


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